

WHAT IS CLAIMED IS:

1 *Sub A* 1. A method of manufacturing an antiperspirant or deodorant product within a
2 container having an application end and an opposite end, the product having an application
3 surface adjacent the application end, the method comprising:

4 (a) delivering a first fluid composition through the opposite end of the container to a
5 mold cavity that is defined at least in part by the container, the mold cavity including a
6 removable insert,

7 (b) allowing the first composition to at least partially solidify;

8 (c) removing the insert from the mold cavity to provide a space; and

9 (d) delivering a second fluid composition to the space that was occupied by the insert;

10 wherein at least one of the first and second compositions includes an antiperspirant
11 salt and/or a deodorant active ingredient.

1 2. The method of claim 1 wherein a first portion of the mold cavity defines an
2 application surface of the product.

1 3. The method of claim 2 wherein the first portion is generally dome-shaped.

1 4. The method of claim 1 further comprising inserting the insert into the container
2 prior to step (a).

1 5. The method of claim 2 wherein the first portion of the mold cavity comprises a
2 factory seal portion of the container.

1 6. The method of claim 1 further comprising providing the insert with a flange that
2 fits securely within the open end of the container.

1 7. The method of claim 1 further comprising providing the insert with a taper to
2 allow it to be easily removed.

1 8. The method of claim 1 further comprising applying downward pressure to the
2 insert during delivery of the first composition.

1 9. The method of claim 8 further comprising providing the insert with a pressure
2 ridge to sealingly engage an inner surface of the mold cavity.

1 10. The method of claim 1 wherein the first composition and second composition are
2 different colors.

1 11. The method of claim 10 wherein the second composition defines a stripe
2 extending through the first composition, when the application surface of the antiperspirant
3 product is viewed from above.

1 12. The method of claim 1 further comprising (e) allowing the second composition to
2 at least partially solidify.

1 13. The method of claim 12 further comprising (f) applying a package base to close
2 the open end of the container before or after the second composition has at least partially
3 solidified.

1 14. The method of claim 13 wherein the package base includes an advancement
2 device constructed to advance the antiperspirant product out of the container.

1 15. A method of manufacturing an antiperspirant or deodorant product having a
2 generally dome-shaped application surface, the method comprising:

3 (a) delivering a first fluid composition to an open end of a mold cavity, a first portion
4 of the mold cavity defining the dome-shaped application surface, the mold cavity including a
5 removable insert,

6 (b) allowing the first composition to at least partially solidify;

7 (c) removing the insert from the mold cavity to provide a space; and

8 (d) delivering a second fluid composition to the space that was occupied by the insert;

9 wherein at least one of the first and second compositions includes an antiperspirant
10 salt and/or a deodorant active ingredient.

1 16. The method of claim 15 wherein the insert includes a curved surface shaped to
2 engage the dome-shaped first portion, and the method further comprises inserting the insert
3 into the container, through the open end thereof, until the curved surface sealingly contacts
4 the dome-shaped surface of the first portion.

1 17. The method of claim 16 further comprising providing the insert with a pressure
2 ridge to sealingly engage an inner surface of the mold cavity.

1 18. The method of claim 16 wherein the first composition and second composition
2 are different colors.

1 19. The method of claim 18 wherein the second composition defines a stripe
2 extending through the first composition, when the application surface of the antiperspirant
3 product is viewed from above.

1 20. The method of claim 2 wherein the first portion is defined by a mold member
2 constructed to receive the container in sealing engagement.

1 21. The method of claim 20 wherein the container has a second open end opposite
2 the first open end, and the method further comprises mounting the second open end on the
3 mold member prior to step (a).

1 22. The method of claim 20 further comprising, prior to step (a), inserting the insert
2 into the mold cavity through an opening in the mold member, the opening being constructed
3 to be sealed by the insert.

1 23. The method of claim 22 further comprising, between steps (c) and (d), sealing the
2 opening with a sealing member having a surface constructed to, with the mold member,
3 define the dome-shaped surface of the first portion.

1 24. The method of claim 20 further comprising, after step (d), (e) allowing the
2 second composition to at least partially solidify, and (f) removing the container from the
3 mold member.

1 25. The method of claim 24 further comprising, after step (f), (g) applying a factory
2 seal to the application surface of the antiperspirant product.

1 26. The method of claim 20 wherein the insert extends from and is integral with the
2 mold member.

1 27. The method of claim 26, further comprising, between steps (c) and (d), applying
2 a factory seal to the application surface of the antiperspirant product.

1 28. A method of manufacturing an antiperspirant or deodorant product having a
2 generally dome-shaped application surface including first and second portions, the method
3 comprising:

4 (a) delivering a fluid first composition to an open end of a mold cavity, a first portion
5 of the mold cavity defining the dome-shaped application surface, the mold cavity including
6 an insert constructed to extend from the first portion into the mold cavity towards the open
7 end, and

8 (b) allowing the first composition to at least partially solidify.

1 29. The method of claim 28 wherein the insert comprises a second composition that
2 forms part of the antiperspirant product.

1 30. A method of manufacturing an antiperspirant or deodorant product having an
2 application surface including first and second portions, the method comprising:

3 (a) delivering a first fluid composition to a mold cavity to form the first portion, the
4 mold cavity including a removable insert,

5 (b) allowing the first composition to at least partially solidify;

6 (c) removing the insert from the mold cavity to provide a space; and

7 (d) delivering a second fluid composition to the space that was occupied by the insert,
8 to form the second portion;

9 wherein at least one of the first and second compositions includes an antiperspirant
10 salt and/or a deodorant active ingredient, and

11 wherein the second portion substantially separates two regions of the first portion.

1 31. The method of claim 1 wherein the insert comprises a material selected from the
2 group consisting of metals, coated metals, plastics and silicone-coated plastics.

1 32. The method of claim 31 wherein the material comprises a coated metal selected
2 from the group consisting of stainless steel coated with titanium nitride, chromium, or
3 electroless nickel with or without a polytetrafluoroethylene (PTFE) infusion; aluminum
4 coated with aluminum oxide hardcoat anodizing, hardcoat anodizing with a PTFE infusion,
5 or electroless nickel with or without a PTFE infusion; or aluminum plated with nickel or
6 chrome.